










Date: Monday, 3/17/2008 11:56:51 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI ACCESS HANDLE WELDMENT ASS'Y, LH												
Job Number : 38024													
Estimate Number : 10946													
P.O. Number :	Part Number : D2480011												
This Issue : 3/17/2008 S.O. No. :	Drawing Number : D2480 REV A1												
Prsht Rev. : NC	Project Number : N/A												
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A1												
Previous Run : 36509	Material :												
Written By : <u>08 03 17</u>	Due Date : 3/31/2008 Qty: 2 Um: Each												
Checked & Approved By : <u>08 03 17</u>													
Comment : Est. B1 03.01.09 added Powder Coat													
Additional Product													
Job Number: 													
Seq. #:	Machine Or Operation: Description :												
1.0	D2478 Lower Arm												
 													
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)</p> <p>Lower Arm</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2478</td> <td>Heli Access Handle</td> <td>B 37462 → 1x ✓</td> </tr> <tr> <td></td> <td></td> <td></td> <td>B 34030 → 1x</td> </tr> </tbody> </table> <p><i>ls</i></p>		Qty	Part number	Description	Batch	1	D2478	Heli Access Handle	B 37462 → 1x ✓				B 34030 → 1x
Qty	Part number	Description	Batch										
1	D2478	Heli Access Handle	B 37462 → 1x ✓										
			B 34030 → 1x										
2.0	D2479 Upper Arm												
 													
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)</p> <p>Upper Arm</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2479</td> <td>Heli Access Handle</td> <td>B 34031 → 1x ✓</td> </tr> <tr> <td></td> <td></td> <td></td> <td>B 33502 → 1x</td> </tr> </tbody> </table> <p><i>ls</i></p>		Qty	Part number	Description	Batch	1	D2479	Heli Access Handle	B 34031 → 1x ✓				B 33502 → 1x
Qty	Part number	Description	Batch										
1	D2479	Heli Access Handle	B 34031 → 1x ✓										
			B 33502 → 1x										
3.0	D2481 Lower Mount Plate												
 													
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)</p> <p>Lower Mount Plate</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2481</td> <td>Mounting Plate</td> <td>B 23503 ✓</td> </tr> </tbody> </table> <p><i>ls</i></p>		Qty	Part number	Description	Batch	2	D2481	Mounting Plate	B 23503 ✓				
Qty	Part number	Description	Batch										
2	D2481	Mounting Plate	B 23503 ✓										
4.0	D2482 Upper Mount Plate												
 													
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)</p> <p>Upper Mount Plate</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2482</td> <td>Mounting Plate</td> <td>B 14648 ✓</td> </tr> </tbody> </table> <p><i>ls 08/03/19</i></p>		Qty	Part number	Description	Batch	1	D2482	Mounting Plate	B 14648 ✓				
Qty	Part number	Description	Batch										
1	D2482	Mounting Plate	B 14648 ✓										

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/03/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:56:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, LH

Job Number: 38024

Part Number: D2480011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

LD 08/03/19 (2X)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

LD 08-03-19 (2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/03/19 (2)

8.0

POWDER COATING

POWDER COATING



M107005



(2X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m-l 08/03/20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gl



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.03.20

(X2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Job # 37916

AS 08/03/24

(X2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LD 08/03/24

Job Completion



u 8.03.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

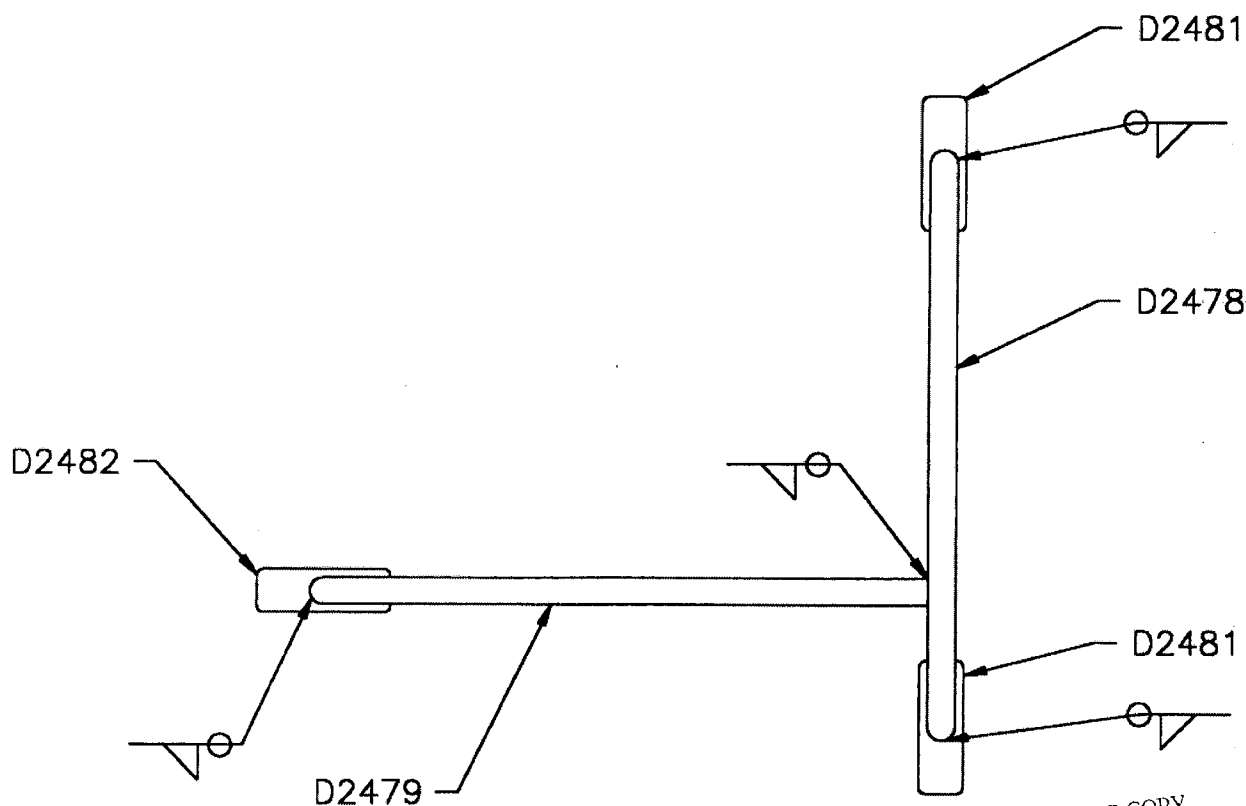
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2480	REV. A SHEET 1 OF 1
DATE 96:05:14		TITLE HANDLE WELDMENT ASSEMBLY	SCALE 6:1
A1 11/11 05.06.23		ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER DS1 004
A1 2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QS1 005

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38024